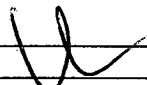
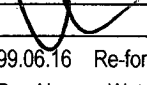


Date: Tuesday, 20/03/2007 8:59:26 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLEVIS
<b>Job Number</b> : 31101	
<b>Estimate Number</b> : 10110	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2012117
<b>This Issue</b> : 20/03/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2012-117 REV. C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 31325	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : 	<b>Due Date</b> : 30/03/2007 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est: C 99.06.16 Re-format, Now Laser Cut DM Est Rev:D Now on WaterJet 07-03-20 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



**Comment:** Qty.: 0.0144 sf(s)/Unit Total: 0.5754 sf(s)  
304/316 .063 Sheet  
Batch: *M101873*

*ml 07 03 26*

*(40)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D2012  
Dwg Rev: *C*  
Prog Rev: *C*

*ml 07 03 26*

*07/03/30*

*(40)*  
*(40)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07 03 26*

*(40)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

*07-03-29*  
*counted.*

*(40)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE  
Form on press using DT8242 as per Dwg D2012-117

*ml 07/04/19*

*x40*

Date: Tuesday, 20/03/2007 8:59:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 31101

Part Number: D2012117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07-04-24* (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*578*

*07/4/24*

(40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(40)  
*07-04-24*

Job Completion



*07-04-24*

Date: Thursday, 3/8/2007 12:36:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 31101		
Estimate Number	: 10110		
P.O. Number	:	Part Number	: D2012117
This Issue	: 3/8/2007 S.O. No. :	Drawing Number	: D2012-117 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	:	Material	:
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est: C 99.06.16 Re-format, Now Laser Cut DM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per DXF File

Material release note is required.

*M301566A*  
*- 013 SF*  
*W. H. H. H. H.*

2.0	D2012117F	Clevis
-----	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

CLEVIS

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/8/2007 12:36:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 31101

Part Number: D2012117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-117

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

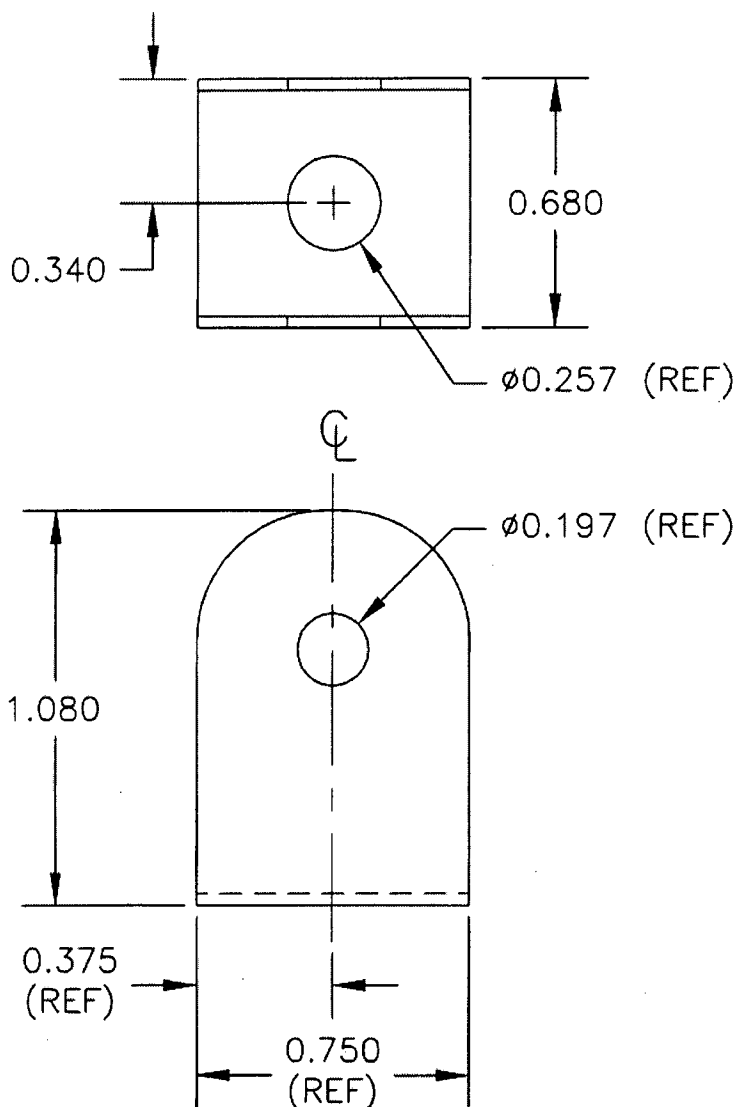
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED <del>RF</del>	DRAWING NO. D2012-117	REV. C SHEET 1 OF 2
DATE 99.05.05	TITLE CLEVIS		SCALE 2:1
A	94.10.27	NEW ISSUE	
B	94.10.27	CHANGED HOLE SIZE, WAS D2012-107	
C	99.05.05	ADD FLAT PATTERN	

RELEASED  
99.05.11 KE



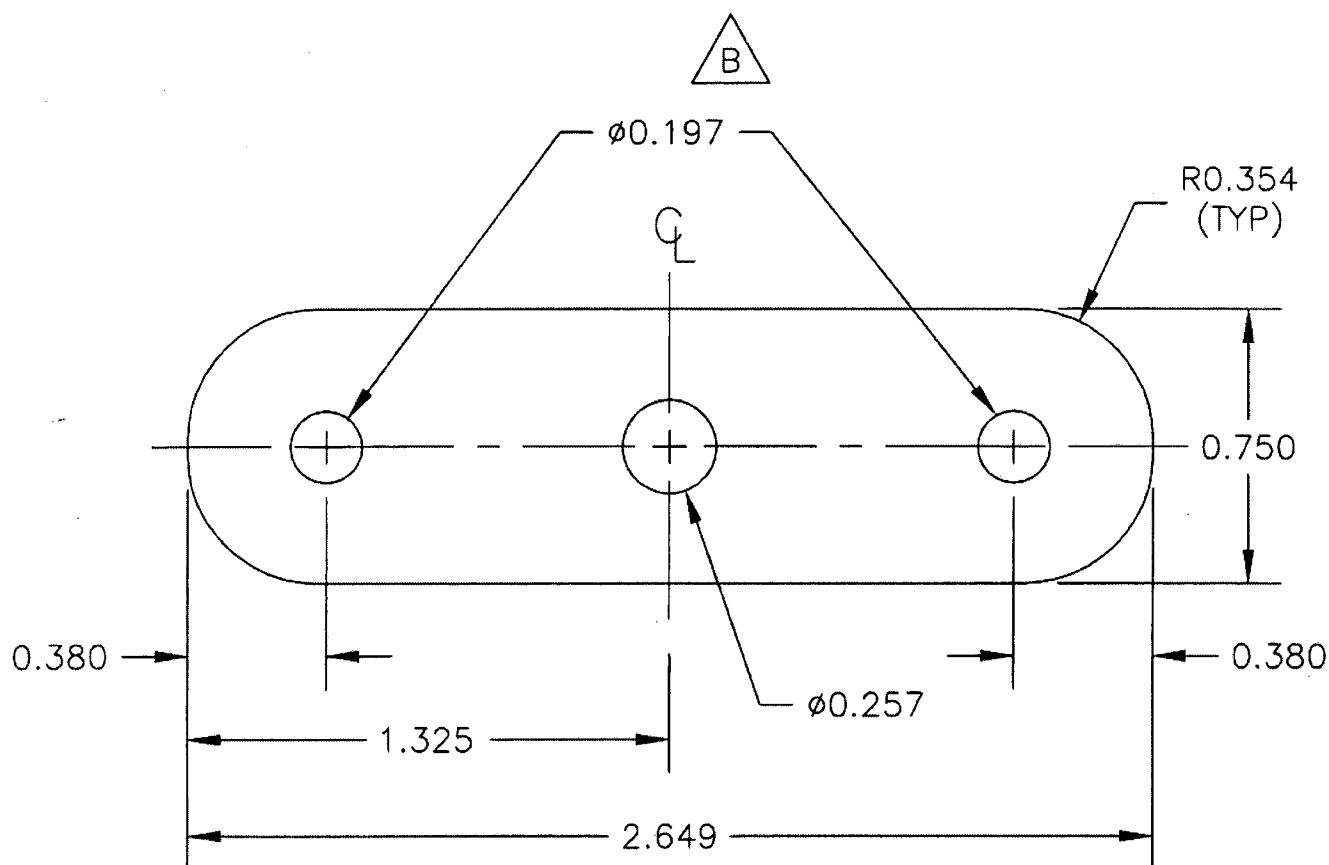
MATERIAL: AISI 304/316 SS 0.063 THICK  
USE 0.032 BEND RADIUS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31101



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2012-117	REV. C SHEET 2 OF 2
DATE 99.05.05		TITLE CLEVIS	SCALE 2:1

RELEASED  
99.05.11 KE



D2012-117 FLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31101

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31101
<b>Description:</b> Clevis		<b>Part Number:</b> D2012-117
<b>Inspection Dwg:</b> D2012-117 <b>Rev:</b> C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.197	+0.005-0.001	0.197	✓		VERN	
B 0.257	+0.006-0.001	0.260	✓		VERN	
C 1.325	+/- 0.010	1.320	✓		VERN	
D 0.380	+/- 0.010	0.374	✓		VERN	
E 0.380	+/- 0.010	0.375	✓		VERN	
F 0.750	+/- 0.010	0.755	✓		VERN	
G 2.649	+/- 0.010	2.641	✓		VERN	
H R0.354	+/- 0.010	R0.354	✓		Radius Gauge	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

<b>Measured by:</b> MM	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 070326	<b>Date:</b> 070329	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	